Date: Wednesday, 16/04/2008 3:45:13 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: 02.750 SUPPORT
Job Number	: 38614		
Estimate Number	: 10829		
P.O. Number	:	**Part Number**	: D28931
This Issue	: 16/04/2008 **S.O. No.** :	**Drawing Number**	: D2893 REV B
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : MACHINED PARTS	**Drawing Revision**	: B
Previous Run	: 38125	**Material**	:
Written By	:	**Due Date**	: 05/05/2008 **Qty:** 20 **Um:** Each
Checked & Approved By	: JLD 08.4.16		

Comment : Est: C 02.11.26 Reformat; Added P/O KJ
est D 06.04.19 removed alodine EC
Est Rev:E Added priming as per Rev B 07-04-30 JLM
est F 08.03.19 Re-format EC verified by: DD

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :	
1.0	DSK078	D2893-1 TURNING DETAIL	
	Comment: Qty.: 0.5000 Each(s)/Unit Total : 10.0000 Each(s) D2893-1 TURNING DETAIL Batch: 38131	JL 08/05/07	20
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
	Comment: HAAS 1 Machine as per Folio FA081 Tumble & Deburr	JL / J.L 08/05/10	20
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	Comment: INSPECT ALL DIM TO DIM SHEET	JL 08/05/10	20
4.0	QC8	SECOND CHECK	
	Comment: SECOND CHECK	S.F 05/05/13	20
5.0	POWDER COATING	POWDER COATING	
	M107550		
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 Mask Inside Bore for Primming	FL 08/05/13	20

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Wednesday, 16/04/2008 3:45:14 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 02.750 SUPPORT

Job Number: 38614 **Part Number:** D28931

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	SPRAY PAINTING	SPRAY PAINTING

Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2893 and QSI 005 4.3. ml 08 05 14 (20)

7.0	~~QC3~~ QC14	INSPECT POWDER COAT/CHEMICAL CONVERSION

08 05 14 (PTJ)

Comment: INSPECT POWDER COAT

8.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: LG ml 08 05 14 (20)

9.0	QC21	FINAL INSPECTION/W/O RELEASE

08/05/15 (JD)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

u 08.05.14

Form: rprocess

Dart Aerospace Ltd

W/O: 38614		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector
08-05-14	7.0	QC 14 required for the priming. Perm. Change 1	M	08/05/15		08 05 14	08-05-14

Part No: D2893-1 **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38614
Description: Ø2.750 Support	Part Number:	D2893-1
Inspection Dwg: D2893 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev B / DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**By**	**Date**
Lathe Section									
A	2.707	2.712							
B	4.946	4.966							
C	3.064	3.084							
D	0.718	0.738							
E	0.090	0.110							
F	2.934	2.954							
G	2.166	2.186							
H	3.890	3.910							
I	0.914	0.934							
J	0.022	0.042							
K	0.109	0.129							
L									
HAAS Section									
AA	2.985	3.005		2.997	2.991	2.991	2.991		
AB	0.440	0.460		.450	.450	.450	.450		
AC	0.125	0.160		.140	.143	.143	.143		
AD	0.040	0.060		.044	.042	.042	.041		
AE	0.188	0.193		.189	.189	.189	.189		
AF	0.125	0.160		.142	.141	.141	.142		
AG	0.140	0.160		.153	.151	.151	.151		
AH	1.360	1.400		1.376	1.376	1.373	1.376		
AI	0.040	0.060		.046	.050	.053	.051		
AJ	1.190	1.230		1.212	1.217	1.216	1.217		
AK	0.010	0.020		.015	.015	.015	.015		
AL	0.053	0.073		.063	.063	.063	.063		
AM	0.240	0.260		.250	.250	.250	.250		
AN	2.518	2.538		2.528	2.528	2.528	2.528		
AO	84.39	90.39		87.39	87.39	87.39	87.39		
AP	0.261	0.266		.261	.261	.261	.261		
AQ	0.053	0.073		.063	.063	.063	.063		
AR									
AS									
Accept/Reject									

Measured by:	J.L
Date:	08/05/08

Audited by	S.F
Date:	06/05/13

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	

DART AEROSPACE LTD	Work Order:	38614
Description: Ø2.750 Support	Part Number:	D2893-1
Inspection Dwg: D2893 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

[X] First Article [ ] Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.992	2.993	2.993	2.987	2.997
AB	0.440	0.460		.450	.450	.450	.450	.445
AC	0.125	0.160		.141	.142	.145	.135	.130
AD	0.040	0.060		.042	.044	.043	.044	.044
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.141	.140	.140	.140	.140
AG	0.140	0.160		.149	.148	.142	.142	.143
AH	1.360	1.400		1.375	1.375	1.370	1.362	1.370
AI	0.040	0.060		.049	.049	.049	.049	.053
AJ	1.190	1.230		1.214	1.215	1.216	1.216	1.213
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
			Accept/Reject					

Measured by:	J.L	Date:	08/05/10
Audited by:	S.S	Date:	06/05/13
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD	Work Order:	38614
Description: Ø2.750 Support	Part Number:	D2893-1
Inspection Dwg: D2893 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

[X] First Article [ ] Prototype

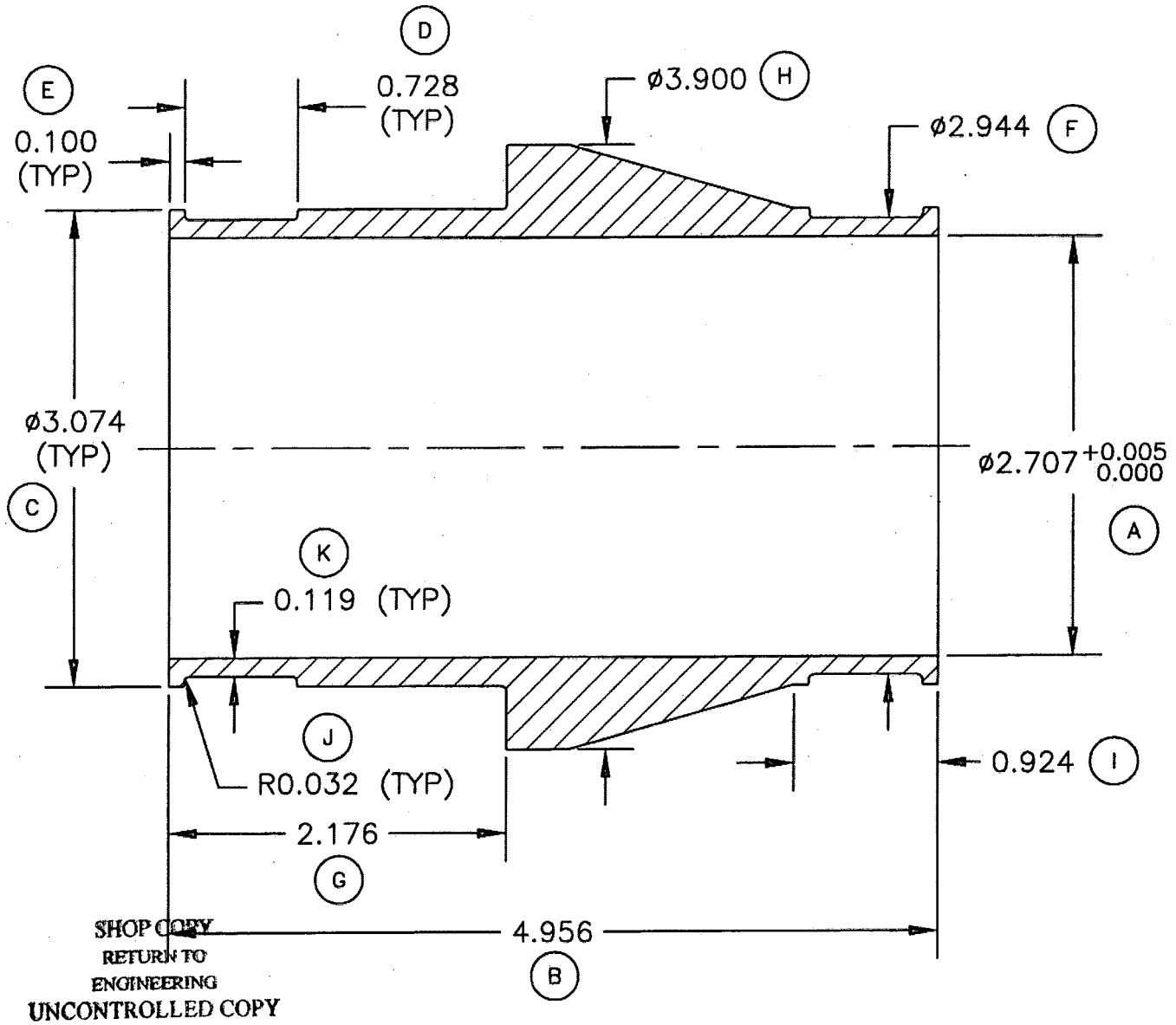
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.992				
AB	0.440	0.460		.442				
AC	0.125	0.160		.130				
AD	0.040	0.060		.042				
AE	0.188	0.193		.188				
AF	0.125	0.160		.143				
AG	0.140	0.160		.144				
AH	1.360	1.400		1.370				
AI	0.040	0.060		.048				
AJ	1.190	1.230		1.215				
AK	0.010	0.020		.015				
AL	0.053	0.073		.063				
AM	0.240	0.260		.250				
AN	2.518	2.538		2.528				
AO	84.39	90.39		87.39				
AP	0.261	0.266		.261				
AQ	0.053	0.073						
AR								
AS								
AT								
			Accept/Reject					

Measured by:		Date:	08/05/10
Audited by:		Date:	08/05/13
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01



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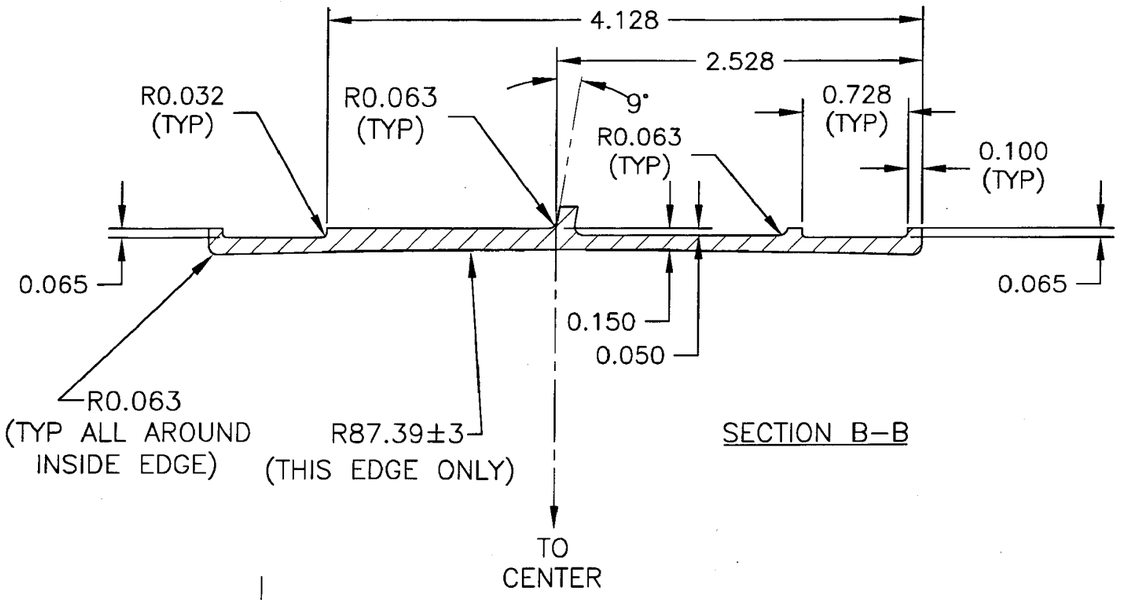
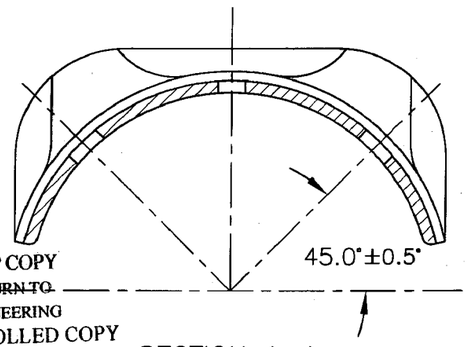
WORK ORDER
NO. 38644

D2893-1 TURNING DETAIL

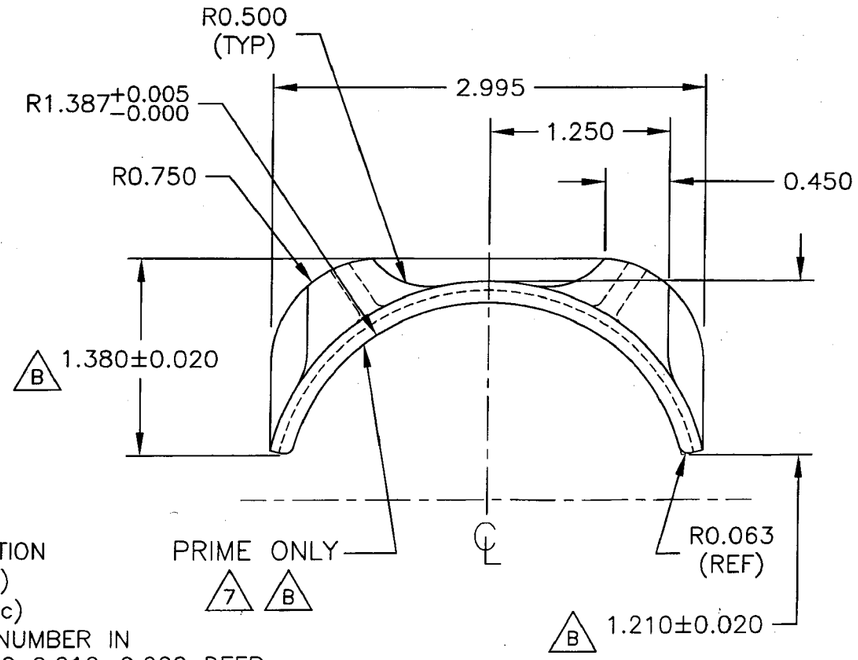


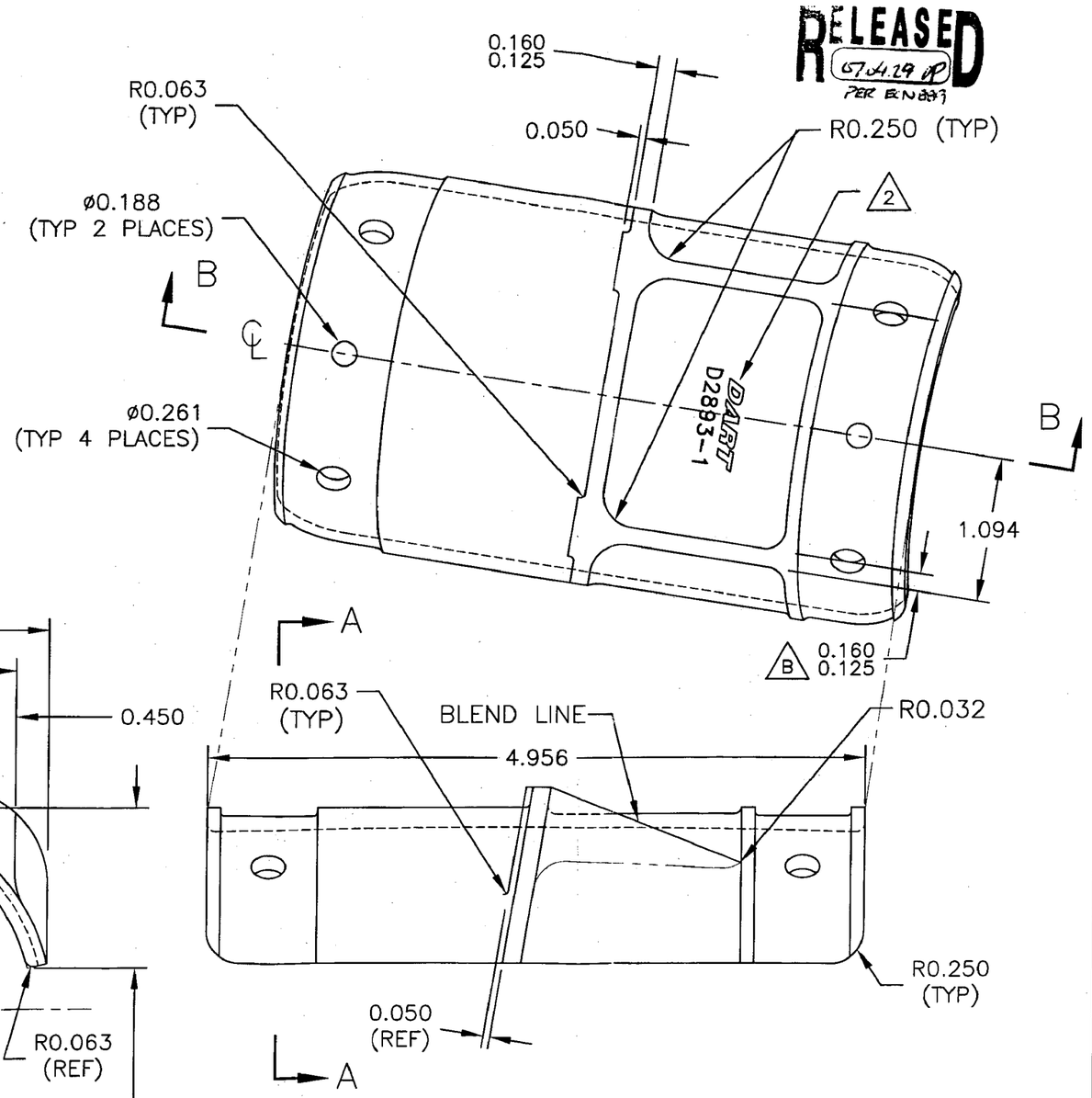
SECTION B–B



SECTION A–A

TOOLING HOLE DETAIL





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NO. 38614

D2893–1

1) MATERIAL: 17–4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRc)
2) IDENTIFY WITH DART LOGO AND PART NUMBER IN
THIS AREA WITH 0.125 HIGH LETTERING 0.010–0.020 DEEP
3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
4) PART IS SYMMETRIC ABOUT CENTERLINE
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES
7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

B	07.03.16	UPDATE DIMS AS MFG., PRIME INSIDE
A	01.01.10	NEW ISSUE

DESIGN GP	DRAWN BY BH	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2893	REV. B SHEET 1 OF 1
DATE 07.03.16		TITLE ø2.750 SUPPORT	SCALE 1:1